

Date: Monday, 08/06/2009 1:12:00 PM
 User: Julie Dawson

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : WEB
Job Number : 48412	
Estimate Number : 10195	
P.O. Number :	Part Number : D21741
This Issue : 08/06/2009 S.O. No. :	Drawing Number : D2174-1 REV E
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : SMALL /MED FAB	Drawing Revision : E
Previous Run : 37848	Material :
Written By :	Due Date : 15/06/2009 Qty: 10 Um: Each
Checked & Approved By : <u>JLD 09.06.08</u>	
Comment : Est C 04.06.09 Reformat KJ/RF	
Est Rev:D As per Rev E 06-11-22 JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M2024T3S063	2024-T3 .063 sheet
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Comment: Qty.: 0.4958 sf(s)/Unit Total : 4.9581 sf(s)

Material: 2024-T3 (QQ-A-250/4) 0.063" thick

(M2024T3S.063)

Batch: 110980 B3 9-69

2.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET

1-Cut as per Dwg D2174

Dwg Rev: E

Prog Rev: E

B3 9-69



2-Deburr if necessary

B3 9-69

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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B3 9-69

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

509/06/10 (H6)

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE

Deburr Stack

MAS

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 08/06/2009 1:12:00 PM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEB

Job Number: 48412

Part Number: D21741

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

502/66/10 (11)

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

BL 09-06-11 (11)

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT CHEMICAL CONVERSION COAT

09-06-11

(X11)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: GA

26 09/06/11

(11)

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/06/11

Job Completion



MF
09-06-11

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 48412	
Description: Web		Part Number: D2174-1	
Inspection Dwg: D2174 Rev: E		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

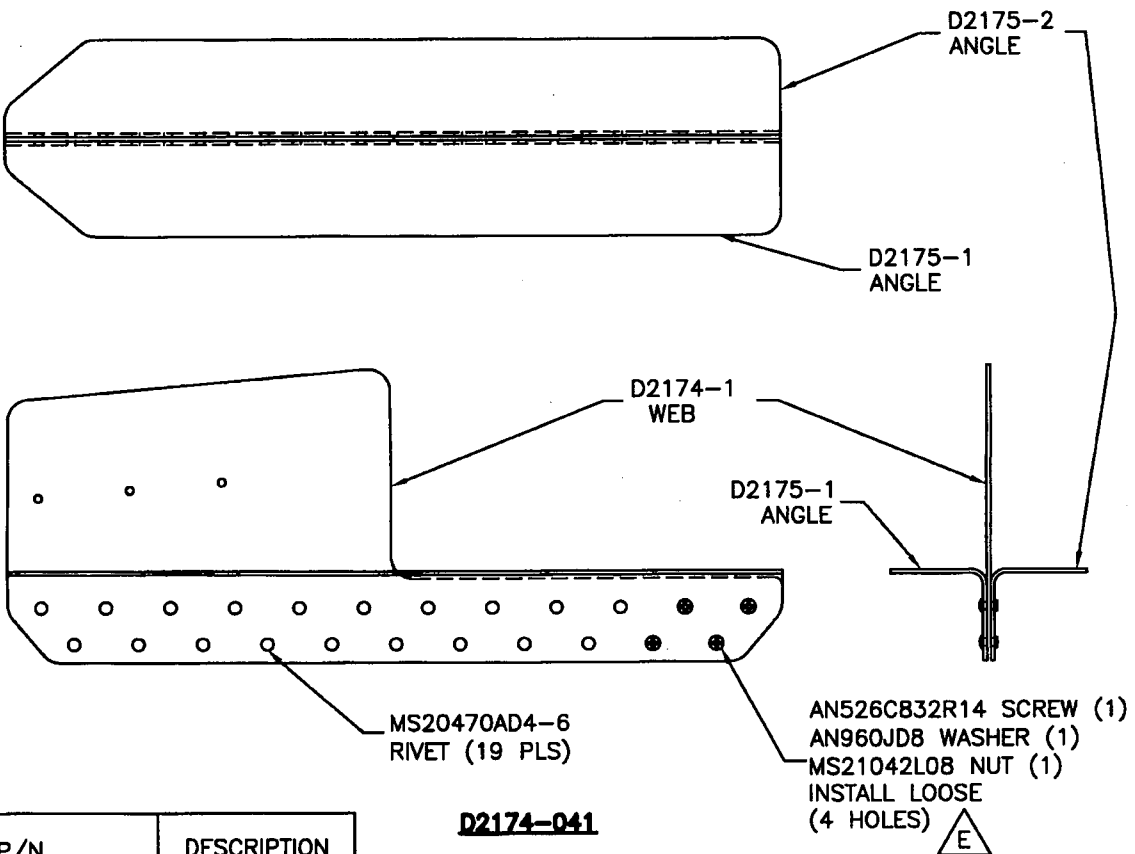
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
6.250	+/-0.010	6.256	X			
6.400	+/-0.010	6.401	X			
4.800	+/-0.010	4.809	X			
1.375	+/-0.010	1.375	X			
1.050	+/-0.005	1.053	X			
Ø0.128	+0.005/-0.001	.130	X			
12.650	+/-0.010	12.650	X			
0.550	+/-0.010	.551	X			
0.900	+/-0.010	.900	X			
1.629	+/-0.010	1.629	X			
1.506	+/-0.005	1.504	X			
11.550	+/-0.005	11.551	X			
50°	+/-0.5°	50°	X			
0.063 thick	+/-0.010	.061	X			
Ø0.172	+0.005/-0.001	.175	X			

Measured by: B	Audited by: S	Prototype Approval:	N/A
Date: 9-6-9	Date: 09/06/10	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.08.12	New Issue	KJ/JLM	
B	07.04.02	Ø0.172 dimension added	KJ/JLM	

DART

DESIGN		DRAWN BY		DART AEROSPACE LTD	
RF		LE		HAWKESBURY, ONTARIO, CANADA	
CHECKED	PH	APPROVED	CH	DRAWING NO.	REV. E
DATE		06.09.25		D2174	SHEET 1 OF 2
				TITLE	SCALE
				WEB ASSEMBLY	1:3
A		95.10.25		NEW ISSUE	
B		96.01.18		RE-DRAWN	
C		00.09.11		UPDATE FINISH SPEC.	
D		04.06.03		RE-DESIGN	
E		06.09.25		INC 4 HOLES TO Ø0.172; CHG HARDWARE	



D2174-041

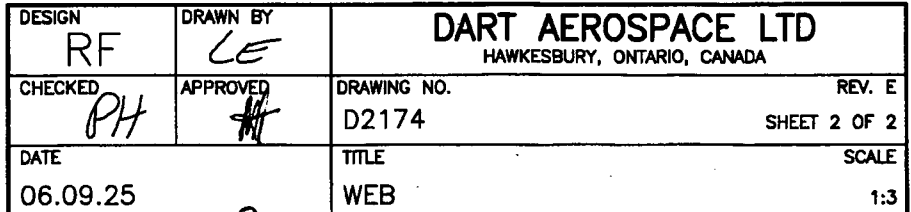
SHOP COPY
RETURN TO
ENGINEERING
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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 28412

QTY	P/N	DESCRIPTION
-041		
X	D2174-041	WEB ASSEMBLY
1	D2174-1	WEB
1	D2175-2	ANGLE
1	D2175-1	ANGLE
4	AN526C832R14	SCREW
4	AN960JD8	WASHER
4	MS21042L08	NUT
19	MS20470AD4-6	RIVET

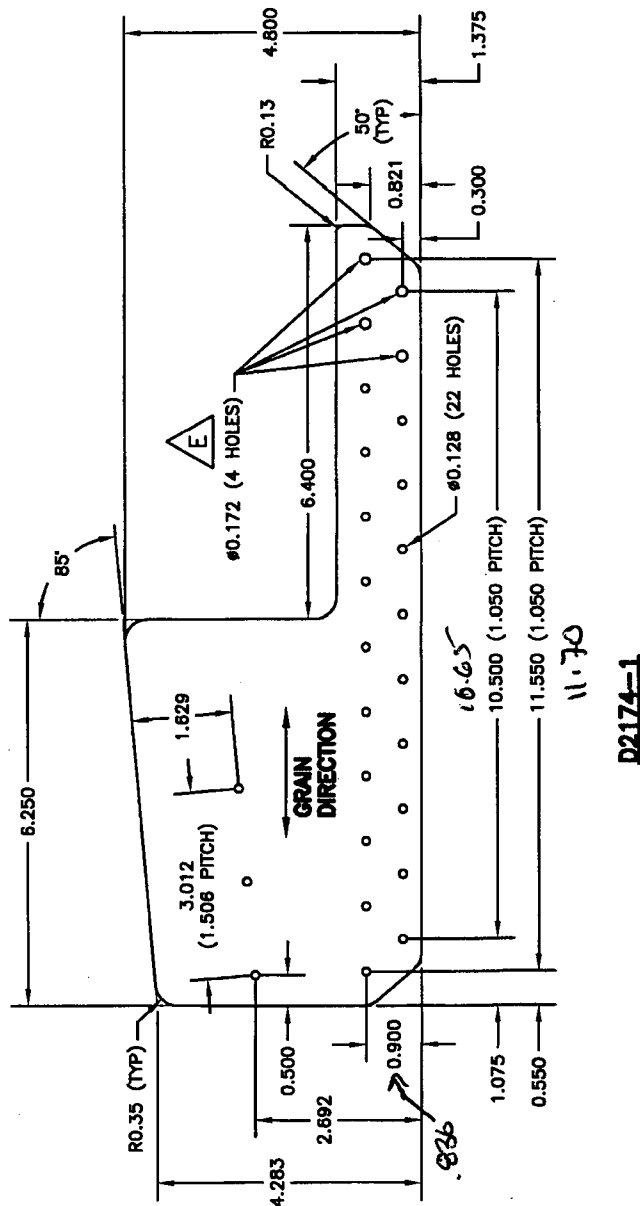
NOTES:

- 1) FINISH: POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) IDENTIFY WITH P/N D2174-041 USING FIND POINT PERMANENT INK MARKER.

RELEASED
06.10.13



RELEASED
06.10.3



NOTES:
1) MATERIAL: 2024-T3 SHEET (QQ-A-200/4) 0.063 THICK (REF. DART SPEC. M2024T3S.063)

- 1) MATERIAL: 2024-T3 SHEET (QQ-A-200/4) 0.063 THICK (REF. DATA)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 5) ALL DIMENSION ARE IN INCHES

MATERIAL: _____
 FINISH: _____
 TOLERANCE: _____
 BREAK: _____
 ALL DIMENSIONS TO CENTERLINE
 UNLESS OTHERWISE SPECIFIED
 1) 2) 3) 4) 5) CONTROLLED COPY
 SUBJECT TO AMENDMENT
 WITHOUT NOTICE
 WORK ORDER
 NO. 48462

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